

Work Order ID 56555

Monday, March 01, 2010 2:54:10 PM

Page 1

Item ID: D2587

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Slug, 350 Hinge

Start Date: 3/2/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-3-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2587

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2587 ☐ Dwg Rev: A1 ☐ Prog Rev: A1 ☐ 2-
Deburr if necessary

6061 . 040

HB 10-3-10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-3-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8.1063/10

counters
x40

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56555

Monday, March 01, 2010 2:54:10 PM

Page 2

Item ID: D2587

Accept

Revision ID:

Item Name: Door Slug, 350 Hinge

Start Date: 3/2/2010 Start Qty: 20.00

Required Date: 3/15/2010 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

10/03/10

(X40)

φ

Memo

0.00

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

10-3-10

⑩ φ

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: 19

0.00

0.00

Rec'd 3/10 (40)

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56555

Monday, March 01, 2010 2:54:10 PM



Page 3

Item ID: D2587

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Slug, 350 Hinge

Start Date: 3/2/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

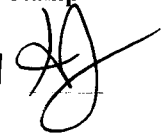


QC

Memo

0.00

Quality Control

10/03/11 
mk
10-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 01, 2010 2:54:09 PM

Page 1

Work Order ID: 56555



Parent Item: D2587



Parent Item Name: Door Slug, 350 Hinge

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP ☐ D ☐ 04.05.31 ☐ Step 2 changed ☐ KJ/JLM ☐
IPP ☐ E ☐ 06.07.31 ☐ Waterjet ☐ EC

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	206.9102	0.3368	7		



6061-T6 .040 Sheet



B 10-3-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

206.9102

100742

3.3

102723

5.93

105842

12

106747

5.7516

107461

8.7841

109396

17.9316

111224

23.0629

113004

128.65

19380

1.5

109396

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

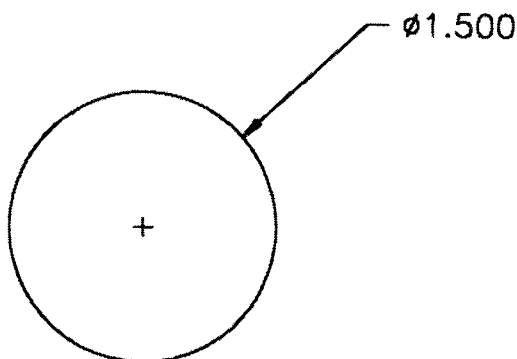
NOTE: Date & initial all entries




DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED <i>M. M.</i>	APPROVED <i>M. M.</i>	D2587	SHEET 1 OF 1
DATE	TITLE		SCALE
96:07:11	DOOR SLUG		1:1
AI <i>K</i> 03.09.16		ADD 6061-T6 OPTION	

RELEASED
96 07 23 B.W.

SS595 #



OR 6061-T6 (QQ-A-200/B OR QQ-A-225/B) 

MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ECTCH, ALODINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries